

Work Order ID 73577

Tuesday, September 06, 2011 8:44:16 AM



Page 1

Item ID: D350-748-141TRN

Accept



Setup Start



Revision ID: ~~U/R~~

Stop



Item Name: Crosstube Turning Detail

Start Date: 9/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/09/06

Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D350-748-141	F U/R	OK	CP	11.09.06					

100	MORI SEIKI CNC LATHE LARGE	0.00							
	Mori Seiki	Memo							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs on both ends as per Folio FA648 2-Turn first side as per Folio FA648 3- File transition lines smooth.								

1 Ø
mm.L 11/09/07

110	QC1- Inspect dimensions to dimension sheet	0.00							
	QC	Memo							
Quality Control									

1 Ø
mm.L 11/09/07

120	MORI SEIKI CNC LATHE LARGE	0.00							
	Mori Seiki	Memo							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA648 2- File transition lines smooth. 3-Scribe Part & Batch as per Dwg D350-748-141								

1 Ø
mm.L 11/09/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, September 06, 2011 8:44:16 AM



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Stop

Cust Item ID:




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Run Start


Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC1- Inspect dimensions to dimension sheet	0.00							
									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									
150		0.00							
	Large Fab								
Crosstubes	Memo	0.00							
Crosstubes	Grind machining marks								

1 ϕ
mm 2 11/09/07

11-9-12

DCI  11-9-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 73577

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Page 3

Item ID: D350-748-141TRN

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Start Date: 9/6/2011 Start Qty: 1.00

Required Date: 9/16/2011 Req'd Qty: 1.00

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Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Outsource process - Heat Treat 0.00



Outsource1

Outsource process - Heat Treat

Memo

Issue P/O: 15625
Heat Treat to min 180 KSI As per Dwg D350-748-141
(MIL-T-6736 OR AMS 2759-1C)
Sand Blast tube after Heat Treat
Possible Supplier: Vac Aero
Ensure Certificate of Conformity is attached

0.00

R11-09-27

170 Receive & Inspect for Damage & Mat'l Certs 0.00



Packaging

Packaging

Memo

Ensure certificate of conformaty is attached

0.00

R11-11-02 (1)

180 QC6- Inspect dimensions to drawing 0.00



QC

Quality Control

Memo

0.00

R11-11-03 (1)

W/O:		WORK ORDER CHANGES					
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Work Order ID 73577



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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
	Packaging								
Packaging	Memo	0.00	MO	11/11/17					
Packaging	Identify and stock in kanban rack Location: <u>LG</u>								
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/11/17

11/11/07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 06, 2011 8:44:14 AM

Page 1

Work Order ID: 73577



Parent Item: D350-748-141TRN



Parent Item Name: Crosstube Turning Detail


Start Date: 9/6/2011

Required Date: 9/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec
IPP Rev B Removed polish 08.04.02 EC verified by : DD
IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C
11.02.24 as per dwg rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6017-115  Crosstube Material		Manufactured	No				Each	10.0000		1			



Location

Loc Qty

Loc Code

LG

10

10

32912



mm.l 11/09/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73577
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	✓		vern	CWC-08
	2.180	+0.005/-0.000	2.184	✓		LI	
	2.180	+0.005/-0.000	2.184	✓		LI	
	2.237	+0.005/-0.000	2.241	✓		LI	
	2.272	+0.005/-0.000	2.275	✓		LI	
	2.306	+0.005/-0.000	2.308	✓		LI	
	2.339	+0.007/-0.000	2.345	✓		LI	
	2.339	+0.007/-0.000	2.345	✓		LI	
	0.062	+/-0.010	.062	✓		vern	CWC-08
	4.26	+/-0.030	4.26	✓		LI	
	R0.063	+/-0.010	.063	✓		RG	
	R0.50	+/-0.030	.500	✓		LI	
	2.240	+0.005/-0.000	2.245	✓		vern	CWC-08
	2.180	+0.005/-0.000	2.185	✓		LI	
SIDE B	2.180	+0.005/-0.000	2.185	✓		LI	
	2.237	+0.005/-0.000	2.243	✓		LI	
	2.272	+0.005/-0.000	2.278	✓		LI	
	2.306	+0.005/-0.000	2.311	✓		LI	
	2.339	+0.007/-0.000	2.345	✓		LI	
	2.339	+0.007/-0.000	2.345	✓		LI	
	0.062	+/-0.010	.062	✓		vern	CWC-08
	4.26	+/-0.030	4.26	✓		LI	
	R0.063	+/-0.010	.063	✓		RG	
	R0.50	+/-0.030	.500	✓		LI	
	110.27	+/-0.060	110.26	✓		tape mm-L-02	

Measured by: mm-L	Audited by: [Signature]	Preliminary Approval:
Date: 11/09/06	Date: 11-9-12	Date:

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
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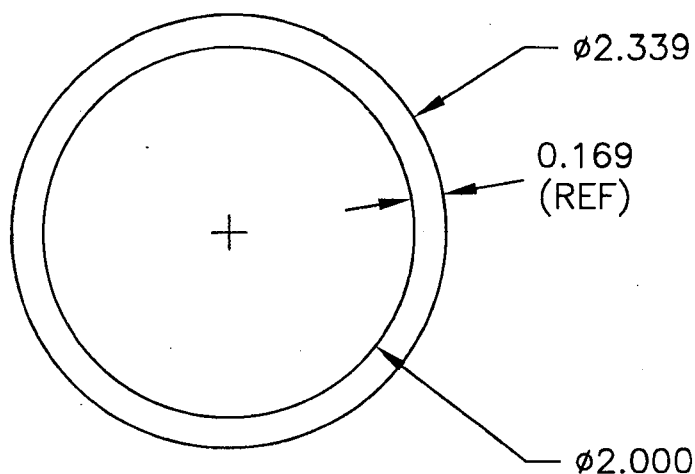
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D6017	REV. A SHEET 1 OF 1
DATE 06.06.30		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	06.06.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



CL1109106
W/O: 73577

NOTES

- 1) D6017-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 115" LONG TUBE: D6017-115

- 2) MATERIAL: AISI 4130 (AMS 6371) SEAMLESS STEEL TUBE
2.339 OD x 2.000 ID
ANNEALED

- 3) TOLERANCES ARE PER ASTM A519 AS FOLLOWS:

O.D.: +0.007/-0.000

I.D.: +0.000/-0.007

LENGTH: XXX +0.188/-0.000

STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED

06.08.15 *#*

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Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 30.45 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

UNDER REVIEW

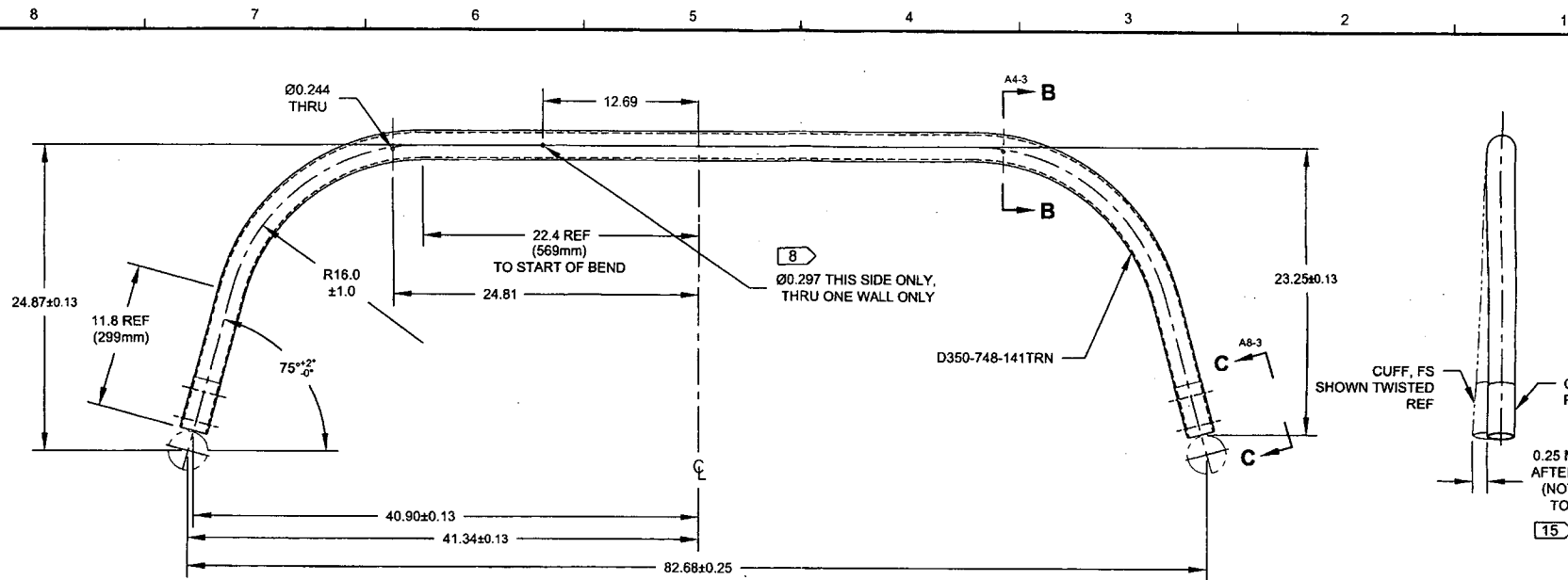
RELEASED
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

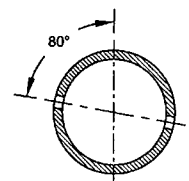
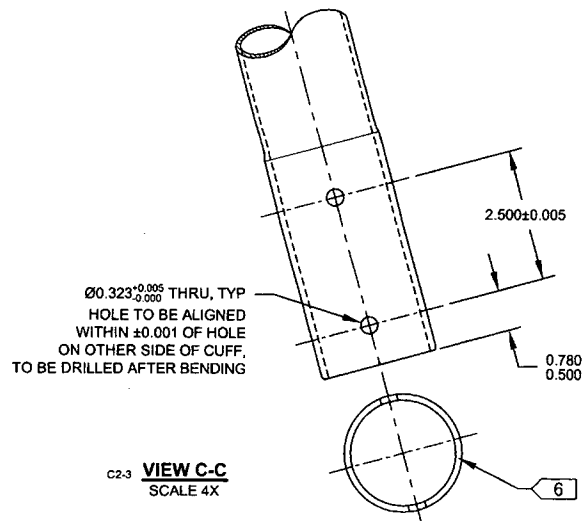
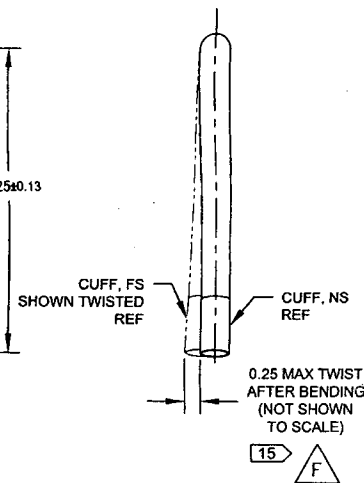
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D350-748-141
REV. F
SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI FWD)
SCALE NTS

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D350-748-141
BENDING AND DRILLING DETAIL 10

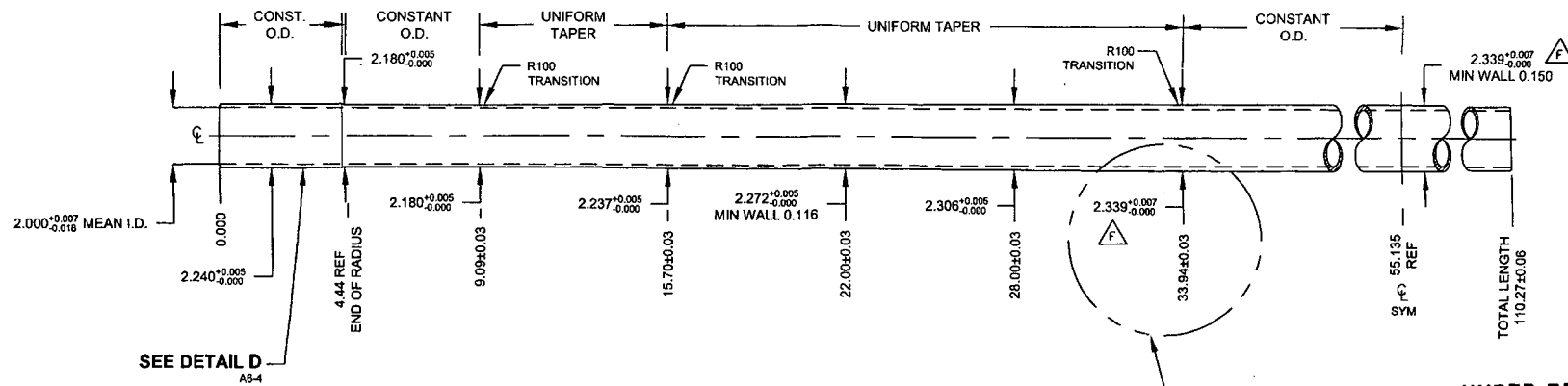


UNDER REVIEW
11.27.12

RELEASED
2011-01-18
JMD

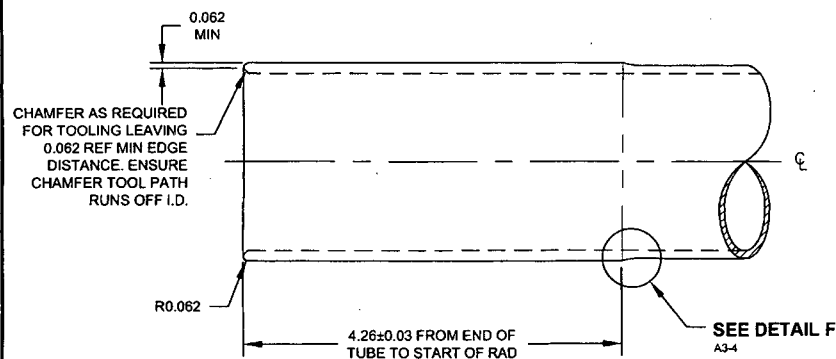
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DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. F
MFG. APPR.	2	D350-748-141	SHEET 3 OF 4
APPROVED	21	TITLE	SCALE
DE APPR.	11	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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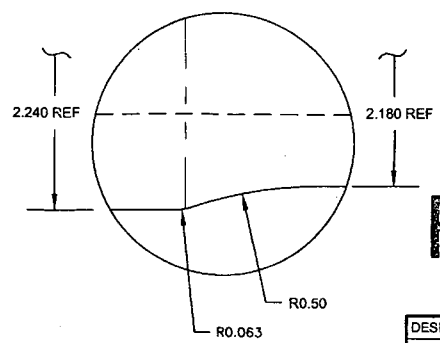


UNDER REVIEW
11.07.12

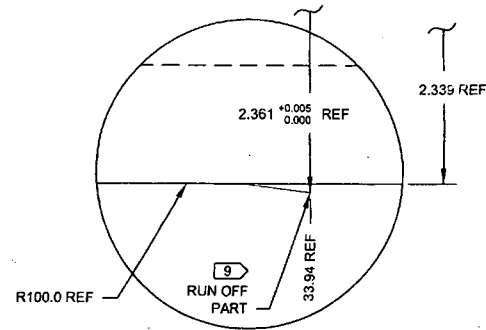
**D350-748-141TRN
TURNING DETAIL**



**DETAIL D:
CROSSTUBE CUFF** C7-4
SCALE 3X



**DETAIL F:
CUFF TRANSITION** A5-4
NOT TO SCALE



**DETAIL E:
TAPER RUN-OFF** C3-4
NOT TO SCALE

RELEASED
2011-01-18

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. F
MFG. APPR.	GP	D350-748-141	SHEET 4 OF 4
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 134819-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

10/28/2011

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/28/2011		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO15028		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141 CROSS TUBE	EA	10	10	
Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E 100% HARDNESS TESTED AS PER ASTM E-18, 40-45 HRC MATERIAL: 4130					
LINE#					
1	73576	1 PIECE			
2	73579	1 PIECE			
3	73574	1 PIECE			
4	73577	1 PIECE			
5	73573	1 PIECE			
6	73578	1 PIECE			
7	73575	1 PIECE			
8	73580	1 PIECE			
9		2 PIECES			

100% HARDNESS TESTED

10 - Pcs.

44/45 HRC

TR.

VALID
THRU
12/25
2011

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



METAL TREATING INSTITUTE

[Signature]
Authorized Q.C. Inspector



Accredited
Nadcap
Heat Treating • Welding

VACUUM BRAZING • HEAT TREATING • SPECIAL PROCESSING • FURNACE EQUIPMENT
SURFACE CORROSION PROTECTION • PLASMA AND OTHER COATINGS